

Work Order ID 86851

July-06-12 3:12:25 PM

86851

Page 1

Item ID: D3293-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 7/06/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-09-10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3293	Rev A								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00 6 0 Jm 12-7-23
 FLOW CNC Waterjet 1-Cut as per Dwg D3293 Dwg Rev: A Prog Rev: A 2-
2624 .080 Deburr if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 6 0 Jm 12-7-23
 Quality Control

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00 6 0 Jm 12-7-23
 Quality Control

SMB
12-7-23
16
12/14/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86851***86851***

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Item ID: D3293-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 7/06/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- Deburr								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

6 12-7-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 7/06/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

10:40
11:10

6X

0

M/L

12/07/24

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

6

0

BP 12-7-24

180

Identify as per dwg & Stock Location

0.00

180

Packaging

Packaging

Memo

0.00

6X

0

BP

12-7-25

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Revision ID:

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NS2

Item Name: Doubler

Start Date: 7/06/12

Start Qty: 6.00

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Required Date: 8/03/12

Req'd Qty: 6.00

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Customer:

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Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 12/07/25

UMF
12-07-25.

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 86851

Parent Item: D3293-1

Parent Item Name: Doubler

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A04.08.24New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	213.4700	1.8264	11.535158			

Location

Loc Qty

Loc Code

MAT022

213.47

105411

6

109424

4

112331

3

113796

5

114025

10.7

116604

5.8

117392

19.1

118180

46

119117

25.7

120989

88.17

120989

Jm 12-7-23

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

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WITHOUT NOT
WORK ORD
NO. 6851

DART

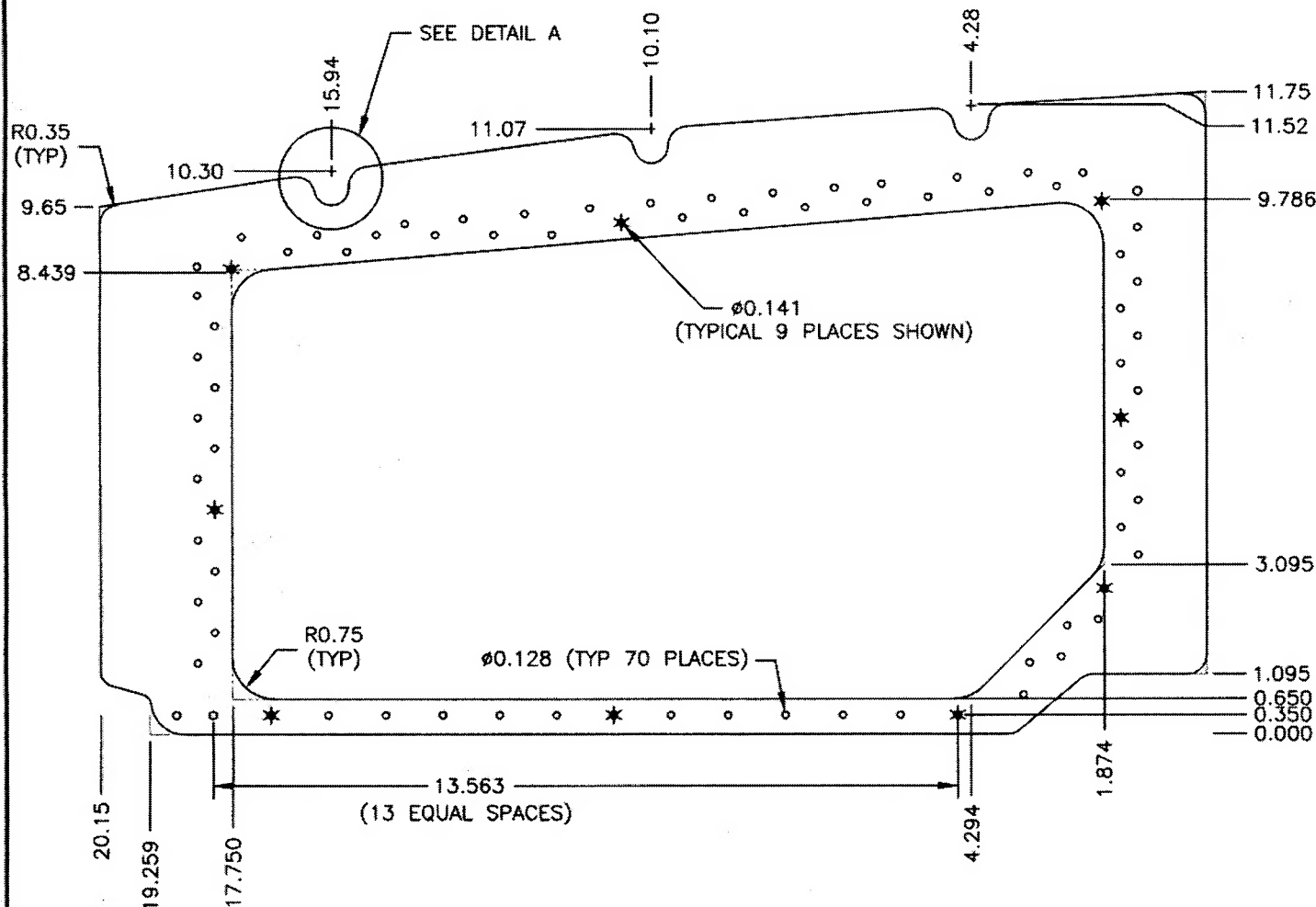
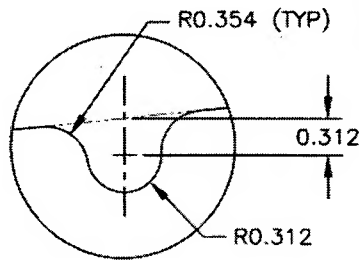
QA CONTROL

DESIGN		DESIGNED BY		DARI AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		
DATE	04.06.28		TITLE	
04.06.28			DOUBLER	
A		04.06.28	NEW ISSUE	
REV. A SHEET 1 OF 1 SCALE 1:3				

1207-10

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

04.07.72



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